

AMENDMENTS TO THE ABSTRACT

Please replace the original abstract with the substitute abstract provided on a separate sheet.

ABSTRACT

~~In a~~ A laser welding method of varying a waveform and a frequency of a laser output in a controlled manner so as to prevent occurrence of weld ~~defects, defects.~~ ~~a~~ A time change in light emission strength of a plasma or ~~a~~ plume generated from a laser welded portion is detected, ~~and~~ a laser output variation condition is set so that the time change in the light emission strength is in response to the variation in the laser output during laser welding is carried out. ~~In a laser~~ The welding method of ~~varying varies~~ the waveform and frequency of a laser output suitably so as to prevent the occurrence of the weld defects, ~~a new laser welding method and~~ can optimize a laser output variation condition more simply and securely.